

Date: Wednesday, 1/24/2007 4:46:47 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L FWD X-TUBE  
 Job Number : 30429  
 Estimate Number : 10553  
 P.O. Number : N/A Part Number : D206667103 BL  
 This Issue : 1/24/2007 S.O. No. : N/A Drawing Number : D206-667-143 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : B  
 Previous Run : 30428 Material : N/A  
 Due Date : 2/28/2007 Qty: 1 Um: Each  
 Written By : 01.01.25  
 Checked & Approved By : 01.01.25  
 Comment : Est Rev: 05.09.01 Add holes for compatibility with Bell  
 Skid tubes KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

2.0

D6002115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D6002-115

Crosstube

B25662

Check OD = 2.250"; ID = 1.750"

ml 07/02/05

1

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

ml 07/02/05

1

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

ml 07/02/05

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff(Donot engrave on outside of tube)

SA 07.02.06 1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SA 07.02.06 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.02.06 1

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

SA 07-02-08 1

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 2-2-8

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SA 07-02-08

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

EL/ET 7-3-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 30429

Part Number: D206667103

Job Number:



Seq. #: Machine Or Operation: Description :

12.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

20703-120

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

IT  
020724

JD 7-4-2

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-4-2

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

02/04/26

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

02/04/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #: Machine Or Operation: Description :

17.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 3644 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

CL 07/004260

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

CL 07/05/07

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

CL 07/05/07

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside cross tube as per QSI 005 4.2

2-Paint outside cross tube with White Imron as per QSI 005 4.2

RT 07-05-09  
RT 07-05-15

21.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

ML 07 05 15 15

(1)

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total: 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip

30822

RT 07-05-15

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

31/92

RT 07-05-15

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 29107

RT 07-05-15

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1 Support 32312

RT 07-05-15

26.0

MS20601AD4W8



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet 102870

RT 07-05-15

27.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20 Clamp 102712

RT 07-05-15

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

RT 07-05-15  
RT 07-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

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Drawing Name: 206L FWD X-TUBE

Job Number: 30429

Part Number: D206667103

Job Number:



Seq. #: Machine Or Operation: Description :

29.0

QC5

INSPECT WORK TO CURRENT STEP



*For AS-18 ①*



Comment: INSPECT WORK TO CURRENT STEP

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: *M102115* ✓

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: *M102536* ✓

33.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-7A

Bolt

*M102140* ✓

34.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt

*M102472* ✓

35.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

*M103641* ✓

*7/5/1859*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/18

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 30429

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



*c20710518*



Comment: INSPECT 100% KITS FOR COMPLETENESS

*7/15/18*

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

*Rev 0 7/15/18*

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*7/15/18*

Job Completion



*W 7/15/18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	30429
<b>Description:</b> Crosstube Assembly (206L High Fwd)	<b>Part Number:</b>	D206-667-143
<b>Inspection Dwg:</b> D206-667-143 <b>Rev:</b> B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.240	—		
	1.982	+0.005/-0.000	1.986	—		
	2.019	+0.005/-0.000	2.023	—		
	2.058	+0.005/-0.000	2.063	—		
	2.097	+0.005/-0.000	2.100	—		
	2.136	+0.005/-0.000	2.140	—		
	2.176	+0.005/-0.000	2.180	—		
	2.201	+0.005/-0.000	2.205	—		
	0.125	+/-0.010	0.131	—		
	0.400 x 30°	+/-0.010	0.400x30°	—		
	R0.063	+/-0.010	R0.063	—		
	R0.500	+/-0.010	R0.500	—		
	4.438	+/-0.030	4.438	—		
SIDE B	104.98	+/-0.020	104.98	✓		
	2.240	+0.005/-0.000	2.242	✓		
	1.982	+0.005/-0.000	1.985	✓		
	2.019	+0.005/-0.000	2.023	✓		
	2.058	+0.005/-0.000	2.063	✓		
	2.097	+0.005/-0.000	2.101	✓		
	2.136	+0.005/-0.000	2.240	✓		
	2.176	+0.005/-0.000	2.180	✓		
	2.201	+0.005/-0.000	2.204	✓		
	0.125	+/-0.010	.130	✓		
	0.400 x 30°	+/-0.010	.400x30°	✓		
	R0.063	+/-0.010	R.063	✓		
	R0.500	+/-0.010	R.500	✓		
	4.438	+/-0.030	4.438	✓		

<b>Measured by:</b>	ML/SD
<b>Date:</b>	07.02.06

<b>Audited by:</b>	RR
<b>Date:</b>	07.02.06

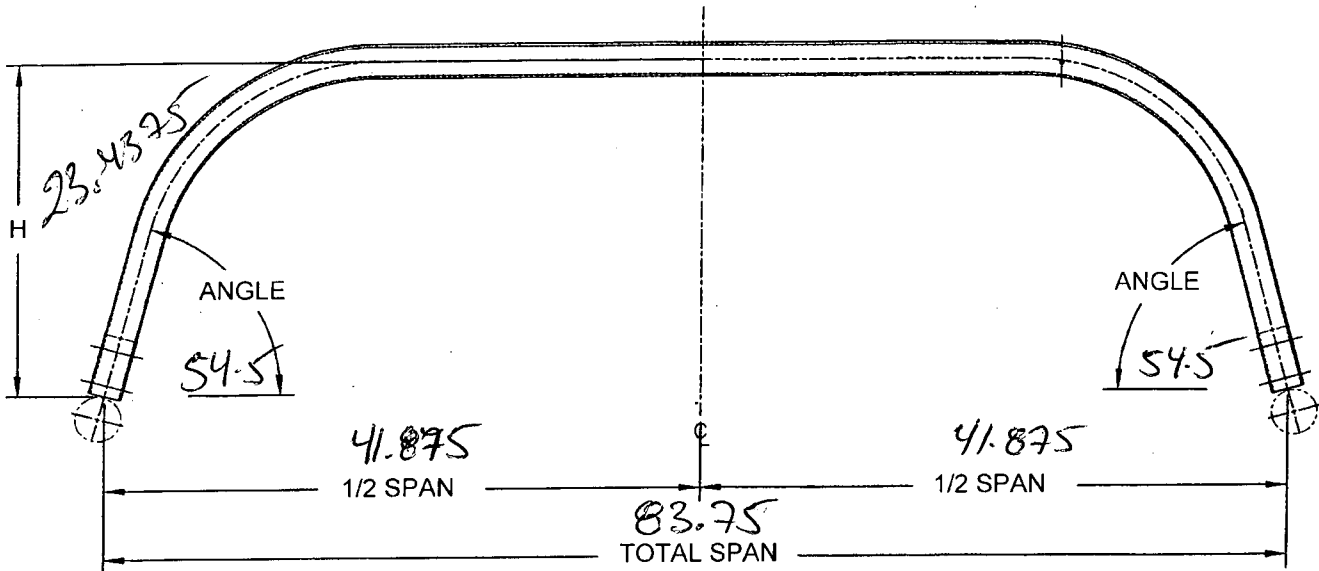
<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	





# Crosstube Bend Dimension Sheet



Height even.

PART NUMBER: 206-667-103

BATCH NUMBER: 30429

DRAWING: 206667143 REVISION: B

H: 23.52

1/2 SPAN: 41.92

TOTAL SPAN: 83.84

ANGLE: 54°

QC 15: 2

DATE: 07.03.12

QTY: 1



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

05-07-26

UNDER REVIEW

05.07.26 PH  
re-draw detail F

PH  
07.01.25

Qty	Part Number	Description
X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
1	D6002-115	CROSSTUBE
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

#### GENERAL NOTES:

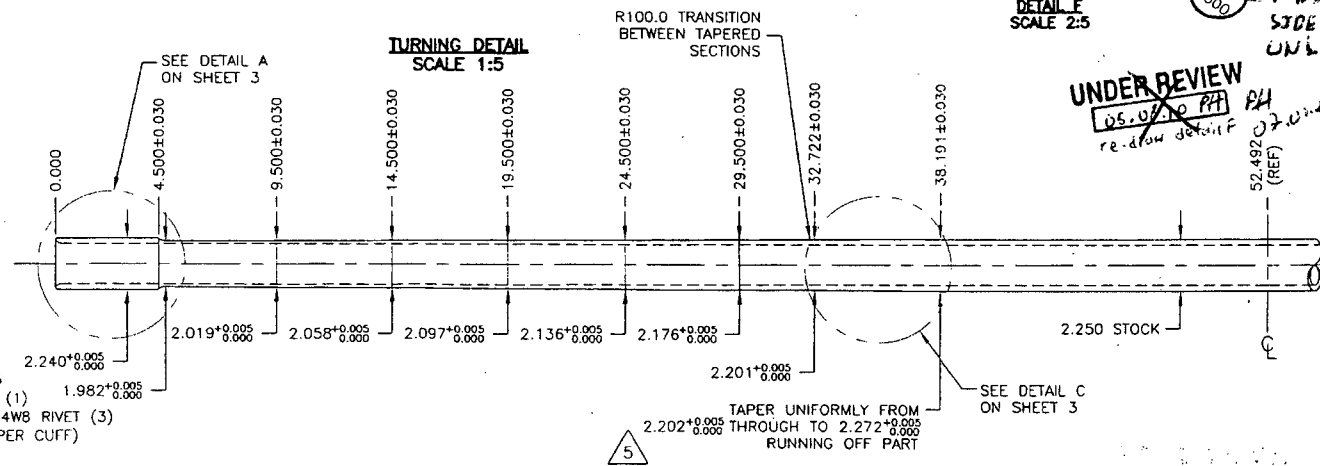
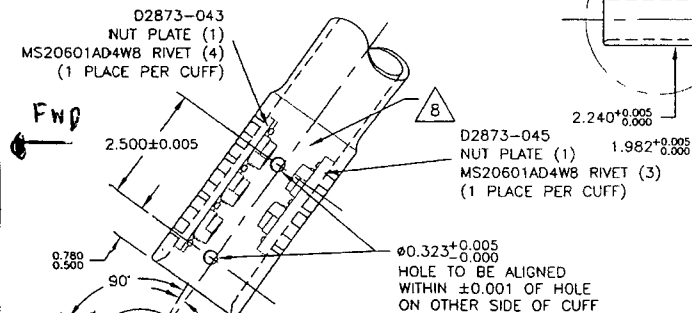
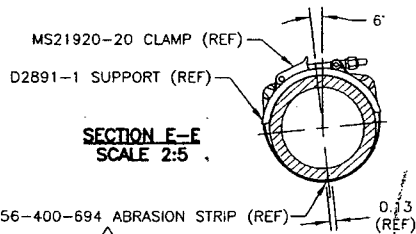
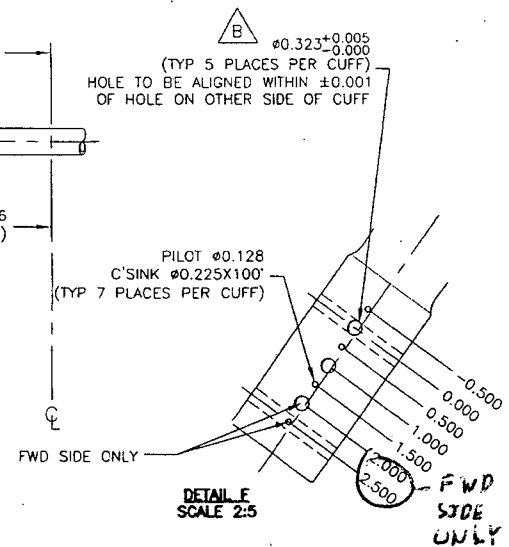
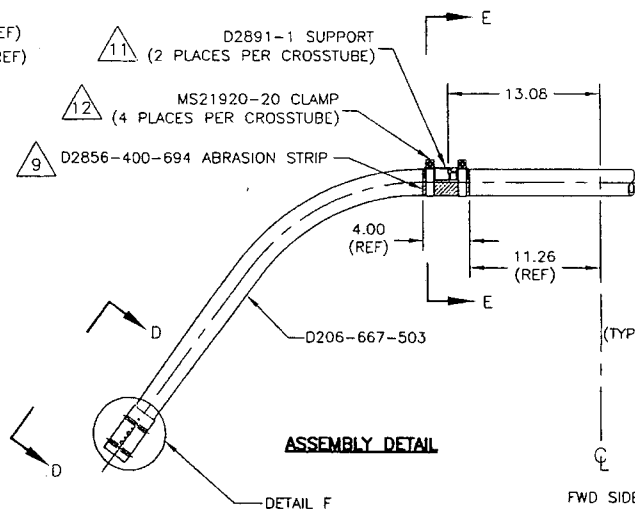
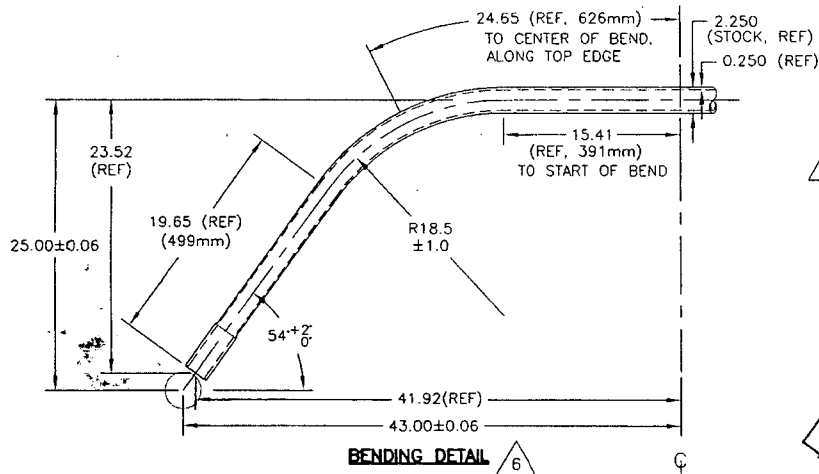
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115  
FINISHED LENGTH =  $104.98 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30429

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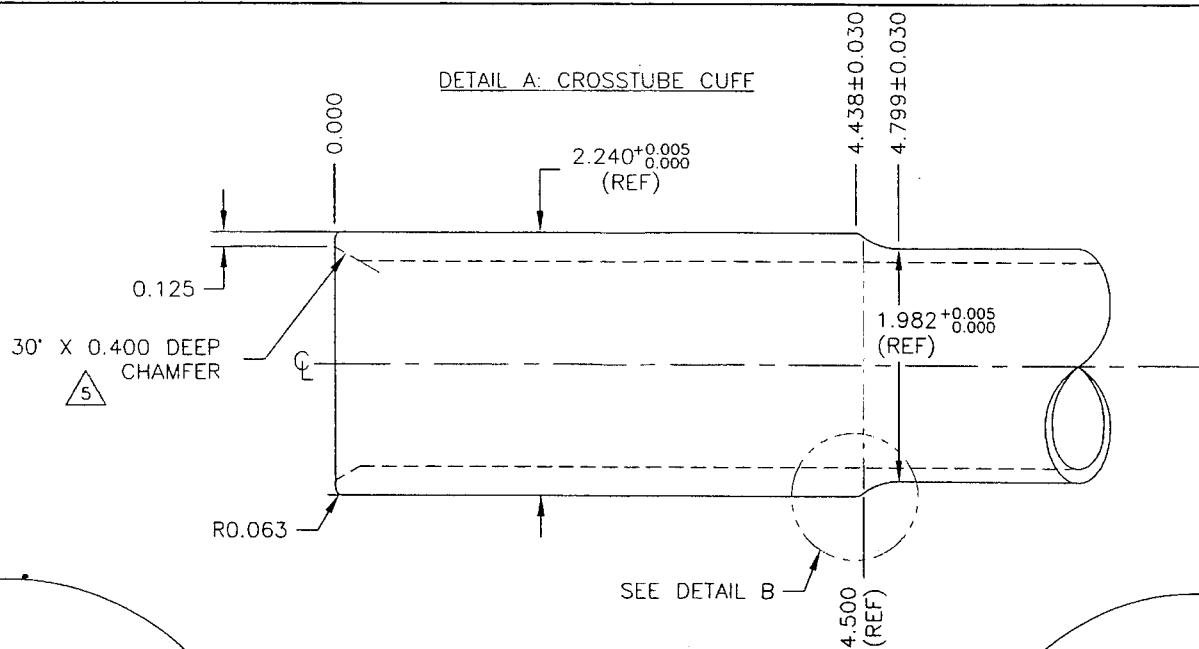




**UNDER REVIEW**  
05.07.26 PH  
re-draw detail F

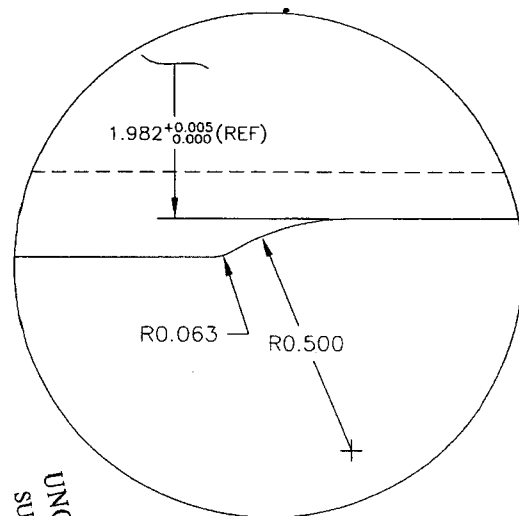
COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA	REV. 8
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED DS	APPROVED DS	DRAWING NO. D206-667-143	SHEET 2 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD)		SCALE 1:10	

NO. 30429  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
FOR COPY



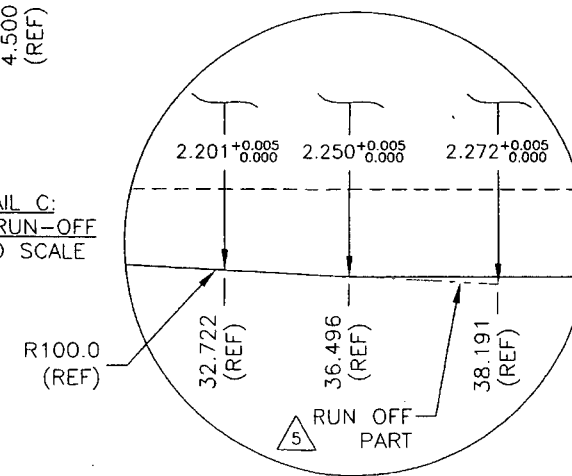
05.07.26 #

~~UNDER REVIEW~~  
06.08.10 PH  
re-draw detail F  
PH  
07.01.25



DETAIL B: CUFF  
TRANSITION  
SCALE 4:1

DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



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		DATE	05.07.26			D206-667-143	SHEET 3 OF 3
						TITLE	SCALE
						CROSSTUBE ASS'Y (206L HIGH FWD)	1:1

NO. 30429  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY





# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36257

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of (13) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D058-676-101 S/N B30250.

Qty(2) P/N D206-667-103 S/N's B30429 and B28979.

Qty (1) P/N D206-667-203 S/N B29635.

Qty(1) P/N D206-667-201 S/N B29098.

Qty (2) P/N D412-664-245 S/N's B31600 and B31598.

Qty (2) P/N D412-664-145 S/N's B31434 and B31152.

Qty (4) P/N D206-667-101 S/N's B30438, B28680, B29101 and B29099.

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (13) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

(13) cross tubes inspected. (10) PASSED / (3) FAILED.

Note: Failed items were serial numbers from above - B30250, B28680 and B29101.  
- tubes were marked in areas requiring rework.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

DATE

April 27, 2007.

INSPECTION  
STAMP(S)

CUSTOMER: Dart Aerospace

P.O. NUMBER

PO 00003644

ADDRESS: fax to 613-632-1053

CONTACT NAME: Linda Lacelle

LABOUR

MATERIALS

TRAVEL EXPENSES

HOTEL EXPENSES

\$

GST

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT



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ADDRESS: fax to 613-632-1053

CONTACT NAME: Linda Lacelle

LABOUR

MATERIALS

TRAVEL EXPENSES

HOTEL EXPENSES

INVOICE NO.

TOTAL \$





Date: Wednesday, 1/24/2007 4:46:47 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L FWD X-TUBE  
 Job Number : 30429  
 Estimate Number : 10553  
 P.O. Number :  
 This Issue : 1/24/2007 S.O. No. :  
 Prsht Rev. : NC Part Number : D206667103  
 First Issue : 1 / 1 Type : LANDING GEAR Drawing Number : D206-667-143 REV B  
 Previous Run : 30428 Material :  
 Due Date : 2/28/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: 05.09.01 Add holes for compatibility with Bell  
 Skidtubes KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

07.02.09

2.0 D6002115 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6002-115 Crosstube

Check OD = 2.250"; ID = 1.750"

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

REFERENCE ONLY